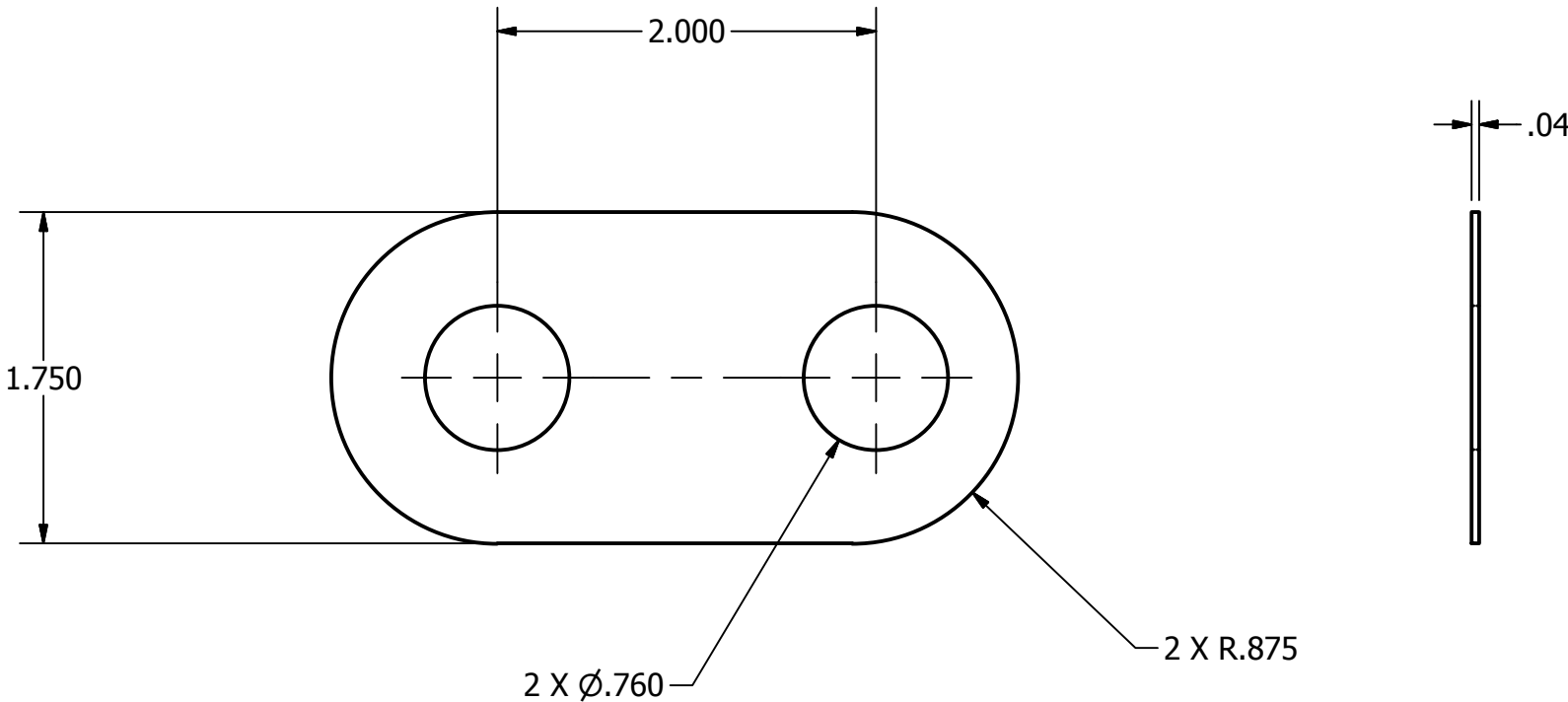



-6 STIFFENER

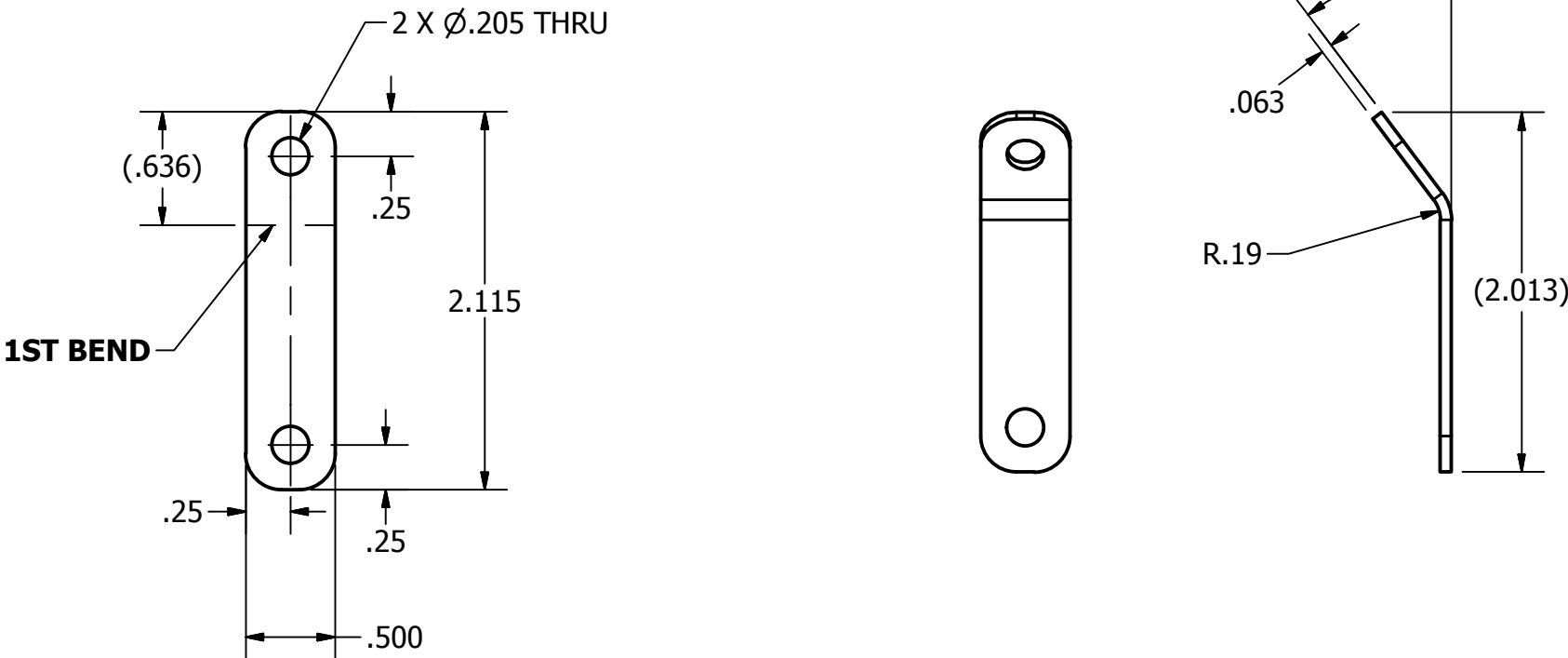
MATERIAL: 301,304,316 1/4 HARD 0.040" THK, MILS-5059-D-Amend. 3, AMS5517, ASTM-A666-94.  
FINISH: NONE



REVISION HISTORY					
DATE	REV	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED
10/19/16	A	ON -15 ADDED FINISH AND PAINT AND ADDED NOTES.	JT	LS	JT
4/5/17	B	MATERIAL THICKNESS WAS 0.06", NOTE 2 TAPE TEST WAS ONCE PER MONTH.	EW	LS	JT
7/19/17	C	REV B AUTHOR WAS ETW, FILLED IN CHECKED BY AND APPROVED INITIALS.	EW	LS	JT
02/22/18	D	ADDED -15 BEND CHART AND -15 REF. HEIGHT.	EW	LS	JT

-15 BRACKET

MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025  
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.  
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.  
PAINT ADHESION TEST:  2



NOTES:

1. PREPARE PART FOR PRIMER:
  - a. USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
  - b. THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
  - c. USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.
2. PAINT ADHESION TEST:

FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.

  - a. DRY TAPE TEST DONE ONCE EVERY LOT.
    - i. PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
    - ii. REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
    - iii. LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.
  - b. WET TAPE TEST DONE ONCE PER LOT.
    - i. SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS.  
(ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
    - ii. DRY THE SURFACE WITH A CLEAN CLOTH.
    - iii. REPEAT STEPS i THRU iii OF DRY TAPE TEST.

BEND CHART	
	1st BEND
PUNCH	#10
DIE	#1
ANGLE	132°
DIMENSION	.636

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PROTO

Paravion® Technology Inc.		TITLE PLUMBING BRACKETS		DRAWING NUMBER 505AC-5500	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY	APRVD. BY	DATE 3/4/16
		DO NOT SCALE DRAWING		REV D	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		3RD ANGLE PROJECTION		SHEET 1 OF 1	
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